

Date: Friday, 11/18/2005 3:04:14 PM
 User: Linda Lacelle

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	WEARSHOE
Job Number :	24846		
Estimate Number :	10615		
P.O. Number :	NIA	Part Number :	D265623
This Issue :	11/18/2005	S.O. No. :	NIA
Prsht Rev. :	NC	Drawing Number :	D2656 REV D
First Issue :	NIA	Project Number :	NIA
Previous Run :	NIA	Drawing Revision :	D
	Type :	Material :	NIA
	PURCHASED PARTS	Due Date :	12/20/2005
Written By :	<u>SEE COMMENT BELOW</u>		Qty: 50 Um: Each
Checked & Approved By :	<u>SEE COMMENT BELOW</u>		
Comment :	Est: D 02.10.25 Re-format KJ		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O: 146

Email or ship DXF file to vendor

Laser Cut per Dwg D2656 flat pattern D2656-23

Material release note required

u 05.11.22

2.0	D265623F	Wearplate
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 50.0000 Each(s)
 Wearplate

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure material release note is attached

DL 05/12/30 50

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

Inspect dimensions per template D2656-23T1

Joe 01/11 49 P10

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr if necessary.

n/a

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06-01-11	4	Took 1 for template. Identify AS 078837 for permanent change	J	06-01-11	1	J	J 06-01-11

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 06/03/13
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 11/18/2005 3:04:14 PM
User: Linda Lacelle

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 24846

Part Number: D265623

Job Number:



Seq. #: Machine Or Operation: Description :

6.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

- 1-Form on Brake as per Dwg D2656 using Jigs DT8261 and DT8326
- 2-Form joggle as per Dwg D2656 using Jig DT8158
- 3-Identify as D2656-23

SP 06/01/25 (49)

7.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

206-01-25 49

8.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

Q.M. 04-02-10

9.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FC 06 02 10

10.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: FP

FC 06 02 10

11.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SP 06/02/13 49 D 06/02/13

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Nov 17, 2005
03:30 pm

Work Order No	: 0024846	Department Code:	
Project Name	: D2656-23	Burden Flags	: NNNNNNNN
Project For	: WK550	WO Status	: Open
Work Order Type	: Main	Invoice State	: Not Invoiced
Main WO Number	:	Invoice Date	:
House Part Number	: D2656-23	Invoice Number	:
Description	: Wearplate	Invoice Amount	: 0.00
Manufactured	: Yes		
Amount Req'd	: 50	Order Entry No	:
Amount Done	: 0	OE Value	: 0.00
Start Date	: 11-17-05		
Est Finish Date	: 12-20-05	Est Margin	: 0.000%
Act Finish Date	:	Actual Margin	: 0.000%
Drawings Req'd	: No		
Ok for Approval	:		
Approval Rec'd	:	\$0 Posted to Finished Goods	

	Estimated	Actual	Var. %	Posted	To Post
=====					
Material Cost	: 0.00	0.00	0.00	0.00	0.00
Engineering Hours	: 0.00	0.00	0.00		
Engineering Cost	: 0.00	0.00	0.00	0.00	0.00
Production Hours	: 0.00	0.00	0.00		
Production Cost	: 0.00	0.00	0.00	0.00	0.00
Packaging Hours	: 0.00	0.00	0.00		
Packaging Cost	: 0.00	0.00	0.00	0.00	0.00
OverHead Hours	: 0.00	0.00	0.00		
OverHead Cost	: 0.00	0.00	0.00	0.00	0.00
CNC Hours	: 0.00	0.00	0.00		
CNC	: 0.00	0.00	0.00	0.00	0.00
Misc. Hours	: 0.00	0.00	0.00		
Misc.	: 0.00	0.00	0.00	0.00	0.00
=====					
Burden	: 0.00	0.00	0.00		
=====					
Total Cost	: 0.00	0.00	0.00		
Margin	: 0.000	0.000			
Selling Cost	: 0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	: 0.00	0.00
Profits/(Loss)	: 0.00	0.00

INSPECTION CERTIFICATE MATERIAL TEST/INSPECTION CERTIFICATES

90229754

YIEN MAU CORP.
YIEN MAU CORP.

INVOICE NO.
COMMODITY:

FORM 165
PRIME COLD ROLLED STAINLESS STEEL SHEET AISI 304 NO.4 (SIC)
FINISH WITH 100 MIC.FILM ON MAIN SIDE, WITH BACK-PASS,
SLITTED EDGE AISI 304, 2B FINISH, WITH PAPER INTERLEAVED,
SLITTED EDGE.
AISI 304

SPECIFICATION:
CUSTOMER:

INTEGRIS METALS LTD

1. 總公司地址: 台灣台北市松山區
345, SHUN AN RD. LI CHU FSIANG
KACHUNG TAIWAN R.O.C.
TEL: (886) 2 2611115 FAX: (886) 2 2611116
CERTIFICATE NO: 90229754
DATE OF ISSUE: 1/18/2004

SPECIFICATION:		CUSTOMER:		SHEET NO.		INTEGRIS METALS LTD		Physical Properties					Chemical Composition							
(ITEM NO) SIZE	NO.	Weight (N.W.)		Heat No.	ID NO.	Tensile Test GL-50 MPa					(%)									
		KGS	LBS			Y.S. (N/mm ²)	T.S. (N/mm ²)	EL. (%)	HRB	HV	C x100	SI x100	Mn x100	P x100	S x1000	NE x100	Cr x100	N x100		
AISI 304 2B (7425-4228)	1	1,465	3,230	YU231320	3AS44453B-21	258	685	56	81	156	4.8	51	119	24	2	804	1821	2.7		
24GA/48"X120"	1	1,464	3,228	YU231320	3AS44453B-22	258	685	56	81	156	4.8	51	119	24	2	804	1821	2.7		
24GA/48"X120" (7425-5860)	1	1,464	3,228	YU230510	38S37609B-51	280	673	53	82	162	5.4	50	126	26	3	815	1819	2.4		
22GA/48"X96" (7425-5950)	1	1,375	3,031	YU230510	38S37609B-52	280	673	53	82	162	5.4	50	126	26	3	815	1819	2.4		
22GA/48"X120" (7425-5860)	1	1,445	3,186	YU134975	3AS43434A-1	312	666	61	82	161	4.1	49	112	24	2	809	1821	2.8		
18GA/48"X96" (7425-2819)	1	1,497	3,300	YU231066	3AS42732-4	301	664	49	84	166	3.7	40	116	27	5	810	1824	3.7		
18GA/48"X120" (7425-2819)	1	1,453	3,203	YU231066	3AS42732-5	301	664	49	84	166	3.7	40	116	27	5	810	1824	3.7		
16GA/48"X120"	1	1,423	3,137	YU231143	3AS42866A-6	302	650	53	82	159	4.5	52	123	28	4	810	1822	2.7		
16GA/48"X120"	1	1,424	3,139	YU231143	3AS42866A-7	302	650	53	82	159	4.5	52	123	28	4	810	1822	2.7		
16GA/48"X120" (7425-7949)	1	1,441	3,177	YU231075	3AS42917A-1	302	650	52	83	162	4.2	48	119	28	6	808	1813	3.4		
14GA/48"X96" (7425-8053)	1	1,420	3,131	YU231075	3AS42917A-2	302	650	52	83	162	4.2	48	119	28	6	808	1813	3.4		
14GA/48"X120" (7425-8240)	1	1,446	3,188	YU135202	3AS45623A-211	301	641	53	81	157	5.1	51	114	30	9	806	1822	3		
14GA/60"X96" (7425-8277)	1	1,405	3,097	YU135202	3AS45623A-213	301	641	53	81	157	5.1	51	114	30	9	806	1822	3		
14GA/60"X120"	1	1,540	3,395	YU135202	3AS45623A-214	301	641	53	81	157	5.1	51	114	30	9	806	1822	3		

NO MERCURY CONTAMINATION
WE HEREBY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN HAS
BEEN MADE IN ACCORDANCE WITH THE RULES OF THE MILL CERTIFICATE.

Product in accordance with ASTM A240, A480,
A262E, ASME SA240, QQ3766D.

YIEN MAU CORP.

Signature
Manager of Quality Assurance

2094 304 4455
(0.037)

po # 267 196



New Zealand Steel Limited
Glenbrook, South Auckland
Postal: Private Bag 92121, Auckland, New Zealand
Telephones: (09) 375 8999 / 375 8111 Auckland
(09) 235 8089 / 235 3535 Waikato
Fax: (09) 375 8950

TEST CERTIFICATE

Ref: 537923850

Reissued 22/8/2005

CUSTOMER	Wilkinson	P50505DI002	SPECIFICATION	ASTMA1008 CS Type A	CERTIFICATE No	TC116858																		
CUSTOMER ON	98-21N-742		PRODUCT	CRA WIDE COIL	PAGE	1 of 1																		
MILL ON	486968		DIMENSIONS	0.033" x 48" x Coil	DATE	19 August 2005																		
PACK NUMBER	HEAT No	CHEMICAL COMPOSITION PERCENT	MECHANICAL TESTS (TEST SPECIFICATION - ASTMA378)																					
		C	Si	Mn	P	S	Cu	Ni	Cr	Mo	V	Nb	Ti	Al	B	N2	CE ()	BEND	YIELD	T.S.	%ELONG	HARDNESS	r	LENGTH
		x100	x1000	x10000	x100	180°																		
R9-466080-00	845423	6	TR	21	11	16	17	20	16	2	3	1	3					Good				58		2700
R9-466081-00	845423	6	TR	21	11	16	17	20	16	2	3	1	3					Good				58		2700
R9-466082-00	845253	6	1	21	10	12	28	30	15	2	3	1	3					Good				47		2651
R9-466083-00	845253	6	1	21	10	12	28	30	15	2	3	1	3					Good				47		2651

2006-01-11

YIELD	GAUGE LENGTH (G.L.)			PLASTIC STRAIN RATIO (r)		IMPACT TEST		CARBON EQUIVALENT VALUE (CE)	
(A)=0.2% PROOF STRESS	(A)=200mm	(C)=80mm	(E)=2"	(A)=0	(C)=r45	(A)=10mm x 10mm	(D)=2.5mm x 10mm	(A)=C+Mn/6	(C)=C+Mn/6+Si/24
(B)=LOWER YIELD STRESS	(B)=50mm	(D)=5.65 S ₀	(F)=8"	(B)=r80	(D)=(r0+r90+2r45) / 4	(B)=7.5mm x 10mm	(E)=5mm x 10mm	(B)=C+Mn/8+(Cr+V+Mo)/5+(Cu+Ni)/15	(D)=

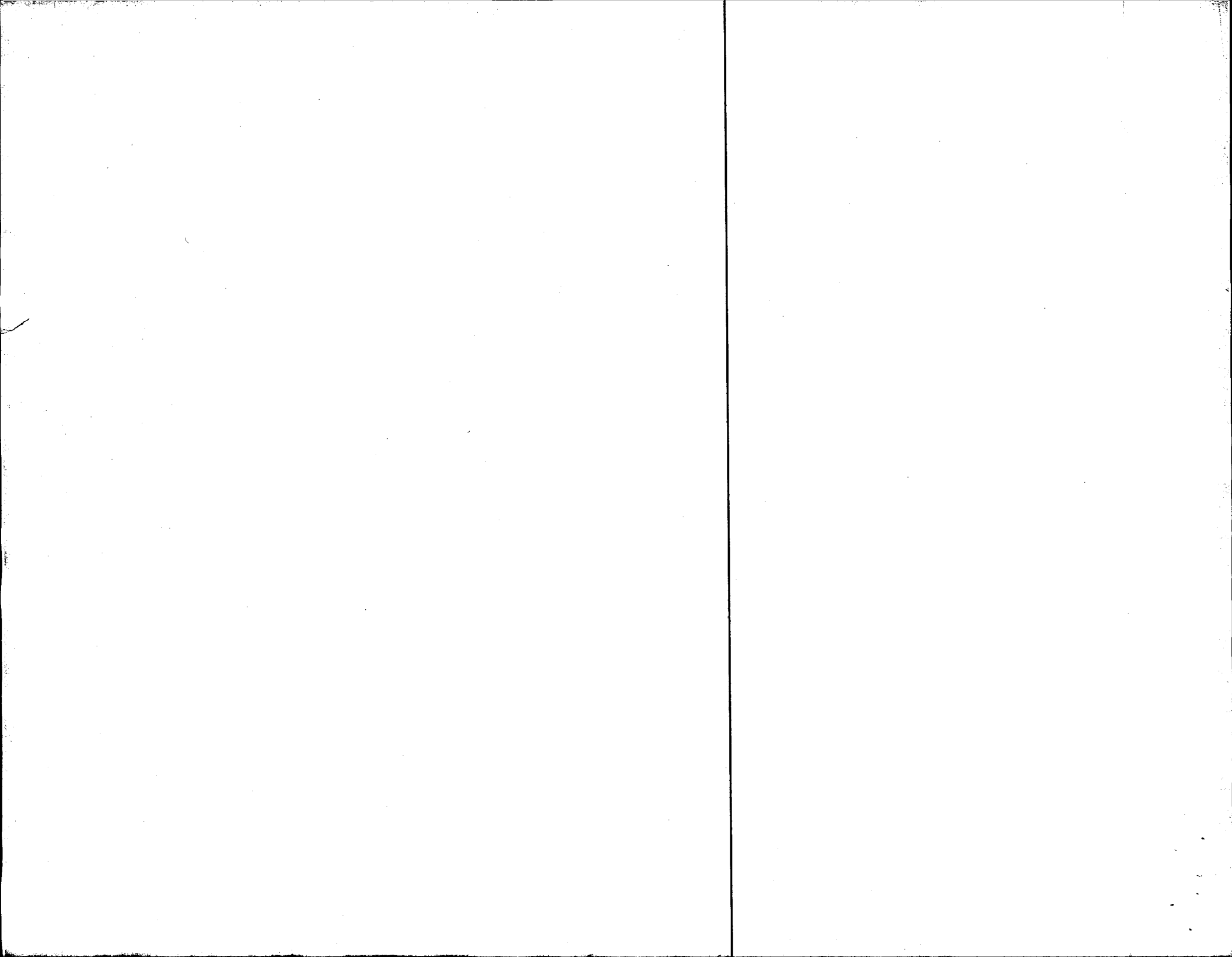
WE HEREBY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN HAS BEEN TESTED AND INSPECTED
WITH SATISFACTORY RESULTS IN ACCORDANCE WITH THE REQUIREMENTS OF THE ABOVE SPECIFICATION

APPROVED *Anish Misra*
QC METALLURGIST

20 gaus

PO# 267, 146

51129ND006-1 T M INDUSTRIAL (P50505DI002.845423)





New Zealand Steel Limited
Glenbrook, South Auckland
Postal: Private Bag 92121, Auckland, New Zealand
Telephones: (09) 375 8888 / 375 8111 Auckland
(09) 235 8069 / 235 3535 Wairuku
Fax: (09) 375 8858

TEST CERTIFICATE

Ref: 521022483

CUSTOMER		Wilkinson		P50323 DI001		SPECIFICATION												ASTMA1908 CS Type A		CERTIFICATE No				TC112397			
CUSTOMER O/N		90-21N-686		PRODUCT												CRA WIDE COIL		PAGE				1 of 1					
MILL O/N		480737		DIMENSIONS												0.055" x 48" x Coil		DATE				09 June 2005					
PACK NUMBER	HEAT No	CHEMICAL COMPOSITION PERCENT																MECHANICAL TESTS (TEST SPECIFICATION - ASTM A370)									
		C	Si	Mn	P	S	Cu	Ni	Cr	Mo	V	Nb	Ti	Al	B	N2	CE ()	BEND	YIELD	T.S.	%ELONG	HARDNESS	r	LENGTH			
		x100			x1000													x10000		x100		180°				GL.*	HRB
R9-459713-00	641758	4	TR	18	4	16	13	19	10	5	3	1	1					Good				54		1585			
R9-459714-00	641758	4	TR	18	4	16	13	19	10	5	3	1	1					Good				54		1457			
R9-459715-00	641513	5	TR	18	9	18	12	17	15	1	6	1	1					Good				48		1375			
R9-459716-00	641513	5	TR	18	9	18	12	17	15	1	6	1	1					Good				48		1473			
R9-459717-00	641756	5	TR	20	12	19	12	18	19	1	7	1	1					Good				48		1631			
R9-459718-00	641756	5	TR	20	12	19	12	18	19	1	7	1	1					Good				48		1093			
R9-459719-00	641756	5	TR	20	12	19	12	18	19	1	7	1	1					Good				50		1562			
R9-459720-00	641756	5	TR	20	12	19	12	18	19	1	7	1	1					Good				50		1535			
R9-460380-00	641761	4	TR	20	13	17	12	18	25	5	8	1	1					Good				50		1581			
R9-460381-00	641758	4	TR	18	4	16	13	19	10	5	3	1	1					Good				49		1562			
R9-460382-00	641758	4	TR	18	4	16	13	19	10	5	3	1	1					Good				49		1503			
R9-461458-00	642309	2	TR	18	10	20	11	17	19	1	6	1	1					Good				48		1785			

YIELD	GAUGE LENGTH (G.L.)			PLASTIC STRAIN RATIO (r)			IMPACT TEST			CARBON EQUIVALENT VALUE (CE)		
(A)=0.2% PROOF STRESS	(A)=200mm	(C)=80mm	(E)=2"	(A)=0	(C)=745	(D)=7.5mm x 10mm	(C)=5mm x 5mm	(D)=2.5mm x 10mm	(E)=5mm x 10mm	(A)=C+Mn/8	(C)=C+Mn/6+Si/24	(D)=
(B)=LOWER YIELD STRESS	(B)=50mm	(D)=5.65? So	(F)=8"	(B)=90	(D)=(r0+r90+2r45)/4	(B)=7.5mm x 10mm	(C)=5mm x 5mm	(D)=2.5mm x 10mm	(E)=5mm x 10mm	(B)=C+Mn/6+(Cr+V+Mo)/5+(Cu+Ni)/15		

WE HEREBY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN HAS BEEN TESTED AND INSPECTED
WITH SATISFACTORY RESULTS IN ACCORDANCE WITH THE REQUIREMENTS OF THE ABOVE SPECIFICATION

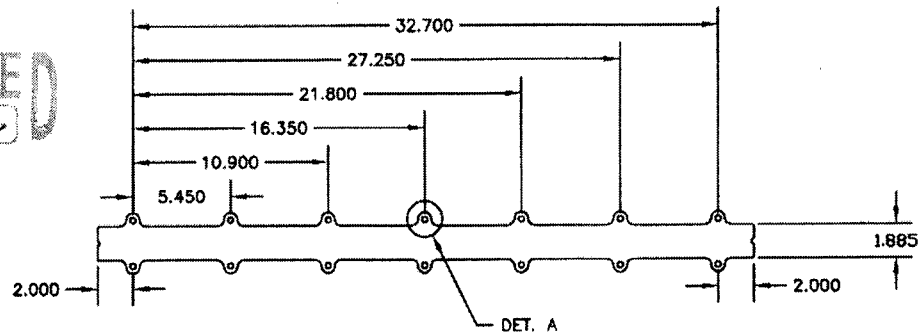
APPROVED *Atish Misra*
QC METALLURGIST

16 ga ms

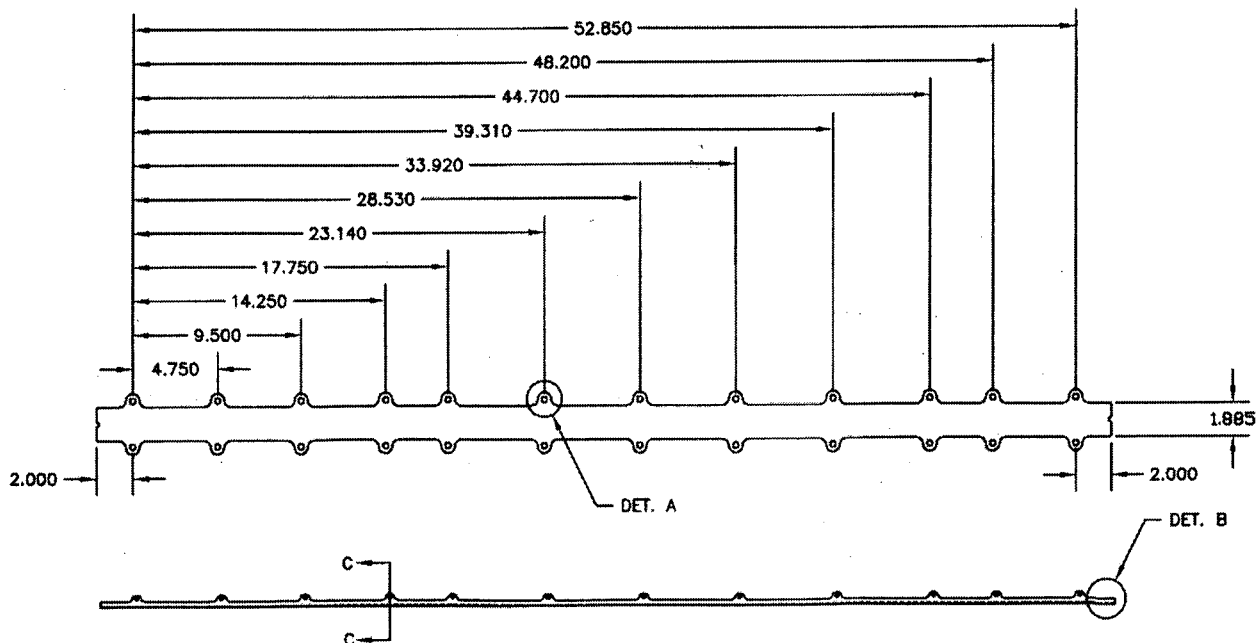
POA 146, 267, 245,

DART

DESIGN DS	DRAWN BY CP	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>A</i>	APPROVED <i>CP</i>	DRAWING NO. D2656	REV. D SHEET 2 OF 4
DATE 05.08.17	TITLE WEARSHOE		SCALE 1:10

RELEASED
*05.08.17***D2656-21**

REFERENCE ONLY

D2656-23**NOTES**

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W
SERIES STEEL, 20 GAUGE (0.040 THICK)
FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED

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